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D3443-3**Job Sheet 201951**

Part No: D3443-3

Job Qty: 6 pcs

Part Name: Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/19

Job Tracking No:

Due Date: 11/28/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev: A 05.11.14 New issue EC

Ship Via:

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	6 pcs		11/28/19	1.00	8.45	Doosan - 1		<i>[Signature]</i>
160	QC 8	6 pcs		11/28/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		<i>mark 19/12/11</i>
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
170	Packaging 3-1 - Stock - B4B	6 pcs ✓		11/28/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B ✓		<i>WA001-6</i>

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					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	

180	QC 21 - SA	6 pcs	11/28/19	0.00 0.00	QC 21 - SA - 21 ✓	WA001-6
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op **100** - (Doosan Lathe), 1-TURN AS PER FOLIO FA588 & DWG D3443
 Descriptions: **160** - (QC8- Inspect parts - second check)
170 - (Identify as per dwg & Stock Location: _____), *****STOCK IN LARGE FAB***** LOCATION: WA001-6
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R1.500	304 Round Bar 1.500	1.5000 ft (.25 ea)	100-Doosan - 1	5100768

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M304R1.500	2	2	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clevis	2.700inches $\pm$ 0.030	2.730 2.670	2.702	
2	Clevis	0.950inches $\pm$ 0.030	0.980 0.920	.948	
3	Clevis	0.500inches + 0.000 - 0.005	0.500 0.495	.498	
4	Clevis	20.00Degrees + 0.05 - 0.50	20.05 19.50	20	
5	Clevis	0.450inches $\pm$ 0.010	0.460 0.440	.4515	
6	Clevis	0.375inches + 0.006 - 0.001	0.381 0.374	.377	
7	Clevis	0.551inches $\pm$ 0.010	0.561 0.541	.555	
8	Clevis	0.625inches $\pm$ 0.010	0.635 0.615	.624	
9	Clevis	1.430inches $\pm$ 0.030	1.460 1.400	1.428	
10	Clevis	0.820inches $\pm$ 0.010	0.830 0.810	.822	
11	Clevis	0.050inches $\pm$ 0.000	0.050 0.050	.046	
12	Clevis	45.0Degrees $\pm$ 0.5	45.5 44.5	45	
13	Clevis	45.0Degrees $\pm$ 0.5	45.5 44.5	45	
14	Clevis	1.000inches $\pm$ 0.030	1.030 0.970	1.001	
15	Clevis	1.125inches $\pm$ 0.010	1.135 1.115	1.126	
16	Clevis	0.438inches + 0.005 - 0.000	0.443 0.438	.4415	
17	Clevis	0.219inches $\pm$ 0.010	0.229 0.209	.221	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					